

20-8636/7/8

017882



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2362-3

Job Sheet 213189

POSITIVE RECALL
EFFECTIVE 2/1/18 AUTH SAA
RELEASED 9-89 DATE 2010-23



Part No: D2362-3

Job Qty: 4 pcs 3

DAS
21
9-02

Part Name: Step Support Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/21/20

Job Tracking No:

Created By: Linda Lacelle

Due Date: 10/2/20

Description:

Note: D2362 REV.G IPP: G 00.05.18 Added inspection level 8 EC IPP REV:H 2020.01.13 AS PER DWG REV.F DD
VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	4 pcs	10/1/20	1.00	1.33	HAAS - 1		1/20-09-30	
						HAAS - 2			
						HAAS - 3			
						HAAS - 4			
110	QC 2	4 pcs	10/1/20	0.00	0.00	QC 2 - 1		mk 20/00/01	
						QC 2 - 12			
						QC 2 - 14			
						QC 2 - 17			
						QC 2 - 19			
						QC 2 - 2			
						QC 2 - 20			
						QC 2 - 22			
						QC 2 - 23			
						QC 2 - 25			
						QC 2 - 32			
						QC 2 - 33			
						QC 2 - 35			
						QC 2 - 39			
						QC 2 - 4			
						QC 2 - 40			
						QC 2 - 44			
						QC 2 - 45			
						QC 2 - 48			
						QC 2 - 49			
						QC 2 - 50			
						QC 2 - 51			
						QC 2 - 52			
						QC 2 - 57			
						QC 2 - 62			
						QC 2 - 63			



Container No: S304376



Part: D2362-3
Job No: 213189
Serial No/Batch: S304376
Revision: REV.G
Inspector:
Exp Date:
Instructions: Various STC's

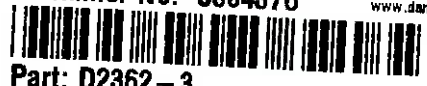
Dart Aerospace Ltd.
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TEL.: 1 813 632-6266
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Date: 18/01/20



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Date: 10/21/20

P.T.O.

				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
120	QC 8	4	10/1/20	0.00 0.00	QC 8 - 12
		pcs			QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
					QC 8 - 66
					QC 8 - 73
					QC 8 - 82
130	Small Fab - 2 - B4B	4	10/1/20	0.00 0.50	Small Fab - 1 - B4B
		pcs			Small Fab - 2 - B4B
					Small Fab - 3 - B4B
					Small Fab - 4 - B4B
					Small Fab - 5 - B4B
					Small Fab - 6 - B4B
					Small Fab - 7 - B4B
					Small Fab - 8 - B4B
					Small Fab - 9 - B4B
					Small Fab - Various 1 - B4B
140	Powdercoat - 1 White GI(A)- B4B	4	10/1/20	0.00 0.15	Powdercoat - 1 - B4B
		pcs			Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
					Powdercoat - 5 - B4B
					Powdercoat - 6 - B4B
					Powdercoat - 7 - B4B

120 QC 8

4
pcs

10/1/20

0.00 0.00

DAS
52
9-89

10/10/21

130 Small Fab - 2 - B4B

4
pcs

10/1/20

0.00 0.50



see Muffin or Chris
prior to powdercoat

Acceptable, ref D2265 Job 213190

Step 1 in Plex,
per Chris - see attached

OCT 18 2020

DAS
58
9-89

140 Powdercoat - 1 White GI(A)- B4B

4
pcs

10/1/20

0.00 0.15

START: 10:20

OUT: 3:30

FINISH: 11:50

20-10-21

DAS
34
9-89

150 QC 3	4 pcs	10/1/20	0.00 0.00	Powdercoat - 8 - B4B	
				Powdercoat - 9 - B4B	
				Powdercoat - 10 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				QC 3 - 82	
				QC 3 - 87	
				QC 3 - 47	
160 Small Fab - 3 - B4B	4 pcs	10/2/20	0.00 0.50	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
				Small Fab - Various 1 - B4B	
170 QC 5	4 pcs	10/2/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	

OCT 21 2020 40 9-89

OCT 26 2020

OCT 28 2020 40 9-89

180 Packaging 3-1 - Stock - B4B	4 3 pcs	10/2/20	0.00 0.00	QC 5 - 82	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B ✓	OCT 2 8 2020 DAS 80
				Packaging 3 - 4 - B4B	ST 639 9-89
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
190 QC 21 - SA	4 pcs	10/2/20	0.00 0.00	QC 21 - SA - 21	DAS OCT 2 8 2020
				QC 21 - SA - 70	21
				QC 21 - SA - 9	9-89
				QC 21 - SA - 77	
				QC 21 - SA - 28	

Part Op 100 - (HAAS CNC vertical machine #1) 1- Mill as per Folio FA800 Rev: AE & Dwg D2362 Rev: G 2-Debur per Descriptions: dwg D2362

110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - (QC8- Inspect parts - second check)

130 - (Small Fab) Debur

140 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: 11:20 FINISH TIME: 11:50

150 - (QC3- Inspect Part Finish)

160 - (Small Fab) Bond rubber D2397-1 followed by D2397-3 using contact cement as per Dwg D2362

Batch _____

170 - (QC5- Inspect part completeness to step on W/O)

180 - (Identify as per dwg & Stock Location: _____)

190 - (QC21- Final Inspection - Work Order Release)

GAI27
GAI28

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2265	Step Bracket	4 pcs (1 ea)	100-HAAS 4 Axis	
D2397-1	Rubber Cushion	4 pcs (1 ea)	160-Small Fab - 3 - B4B	
D2397-3	Rubber Cushion	4 pcs (1 ea)	160-Small Fab - 3 - B4B	

S301882
1x2260469 - 3x2262657
1x2260493 - 3x2262255

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D2265	4	2	0
160-Small Fab - 3 - B4B	D2397-1	4	6	0
	D2397-3	4	6	0

Part Specifications

Specifications could not be found.

Plex 9/21/20 10:08 AM dart.lacelle.linda

Entered: JB Date: NOV 02 2020



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 20-8636

Route update only ☐

Job: <u>213189</u> Part No. <u>D2362-3</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																														
Date: <u>20/10/01</u>		Sequence #: <u>100</u>		QTY Affected: <u>4</u>		MRB (QSI042) <u>INSP</u> <u>12</u> <u>4</u> <u>20/10/15</u>																												
Description Work Order Deviation				Disposition		Completed By																												
<u>all part is not perpendicular</u> <u>the outside wall is not straight.</u>				<u>MRB Acceptable</u>		<u>20/10/01</u> Lead hand / Supervisor																												
						QC / QA Coordinator <u>20-10-23</u>																												
						DAS 9 9-89 <u>20-10-23</u>																												
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☒ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☒ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>					☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☒ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread																															
☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up																																
Other/Details:																																		

Entered: JR Date: NOV 02 2020



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 20-8637

Route update only ☐

Job: <u>213189</u> Part No. <u>D2362-3</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date: <u>20/10/01</u>		Sequence #: <u>100</u>		QTY Affected: <u>1</u>		MRB (QSI042) <u>INSP</u> <u>12</u> <u>9/24/15</u>	
Description Work Order Deviation				Disposition		Completed By	
<u>257 x .75 slot part. 277 x .750</u> <u>part move during process</u>				<u>Acceptable</u>		<u>mk</u> <u>20/10/01</u>	
						Lead hand / Supervisor	
						DAS 9 9-89 <u>20-10-23</u>	
						QC / QA Coordinator	
						DAS 9 9-89 <u>20-10-23</u>	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☒ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☒ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
		Other/Details:					

